

548 DEC 21ST

Work Order ID 154231

154231

Page 1

Tuesday, December 06, 2016 3:04:29 PM

Item ID: D407-728-311

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: OEM Replacement Wearpad 206L Low & 407 Low / High Fits LH or RH

Start Date: 12/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/20/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: VS

DAS
21
9-89

Date: 16/12/17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev N/A

DEC 09 2016

100

Document Control

0.00

DAS
6
9-89

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D407-728-311CHG001

DAS
28
9-89

DAS
21
9-89

DEC 14 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DEC 09 2016

DAS
6
9-89
DAS
27
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

DAS
28
9-89

DEC 14 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 154231

Tuesday, December 06, 2016 3:04:29 PM

154231

Page 2

Item ID: D407-728-311**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** OEM Replacement Wearpad 206L Low & 407 Low / High Fits LH or RH**Start Date:** 12/8/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 12/20/2016 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-728-311 Location: _____ PPP Rev: _____								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS 27 9-89 DAS 28 9-89 DEC 14 2016

DAS 21 9-89 DEC 14 2016

DAS 21 9-89 DEC 14 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Ro ☐ Broken ☐ Inspect ☐ Contamin ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, December 06, 2016 3:04:35 PM

Page 1

Work Order ID: 154231

154231

Parent Item: D407-728-311

D407-728-311

Parent Item Name: OEM Replacement Wearpad 206L Low & 407 Low / High Fits LH or RH

Start Date: 12/8/2016

Required Date: 12/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3339-3 *D3339-3* Wearpad Centre		Manufactured	No			120	Each	2.0000	5	5			
									**	3 x B154232		DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST183	2							
					149515	2							
D3339-5 *D3339-5* Wearpad Fwd		Manufactured	No			120	Each	0.0000	1	1			
									**	154245		DAS 27 9-89	
D3339-9 *D3339-9* Wearpad Aft		Manufactured	No			120	Each	9.0000	1	1			
									**			DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST183	9							
					114166	9							
MS27039-1-08 *MS27039-1-08* Screw		Purchased	No			120	Each	447.0000	28	28			
									**			DAS 27 9-89	
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					FP001	307							
					m136047	307							
					GA	89							
					m128636	89							
					ST281	51							
					m135864	51							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____			

Picklist Print

Tuesday, December 06, 2016 3:04:35 PM

Page 2

Work Order ID: 154231

154231

Parent Item: D407-728-311

D407-728-311

Parent Item Name: OEM Replacement Wearpad 206L Low & 407 Low / High Fits LH or RH

Start Date: 12/8/2016

Required Date: 12/20/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

120

Each

1,725.000

28

28

NAS1149D0332.J

Washer

DAS
6
9-89

DAS
27
9-89

DEC 11 9 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

108

m134848

108

GA

154

m134848

154

ST260a

1200

m136015

1200

ST264

263

m135672

263

28

Tuesday, December 06, 2016 3:04:35 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 154231

Friday, December 09, 2016 8:25:54 AM

154231

Page 1

Item ID: D407-728-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: OEM Replacement Wearpad 206L Low & 407 Low / High Fits LH or RH

Start Date: 12/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/20/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D407-728-311CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
21
9-89

DEC 09 2016

REFERENCE ONLY

IIN-D407-728

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**206 L/ L1/ L3 /L4 SERIES & 407 HIGH/LOW GEAR SERIES and
206 L/ L1 /L3/ L4 & 407 FLOAT GEAR SERIES**

Qty -311	Qty -411	Qty -313	Qty -413	Qty -315	Qty -415	Part Number	Description
							206 L/L1/L3/L4 LOW GEAR & 407 HIGH/LOW GEAR
X						D407-728-311	REPLACEMENT WEARPAD KIT
	X					D407-728-411	SKIDTUBE PROTECTOR KIT
							206 L/L1/L3/L4 HIGH GEAR
		X				D206-728-313	REPLACEMENT WEARPAD KIT
			X			D206-728-413	SKIDTUBE PROTECTOR KIT
							206 L/L1/L3/L4 & 407 FLOAT GEAR
				X		D407-728-315	REPLACEMENT WEARPAD KIT
					X	D407-728-415	SKIDTUBE PROTECTOR KIT
5		6		7	1	D3339-3	CENTER WEARPAD
1						D3339-5	FORWARD WEARPAD
		1		1		D3339-7	LONG FORWARD WEARPAD
1				1	1	D3339-9	AFT WEARPAD
	1					D3340-7	FORWARD SKIDTUBE PROTECTOR
	1					D3340-13	AFT SKIDTUBE PROTECTOR
			1		1	D3340-15	CENTER SKIDTUBE PROTECTOR
			1			D3340-17	AFT SKIDTUBE PROTECTOR
			1			D3340-19	CENTER SKIDTUBE PROTECTOR
					1	D3340-21	AFT SKIDTUBE PROTECTOR
					1	D3340-25	FORWARD SKIDTUBE PROTECTOR
28	28	38	38	46	46	MS27039-1-08	SCREW
28	28	38	38	46	46	AN960JD10L	WASHER
				8	8	NAS1330C3K116	BLIND INSERT

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Revision: **A**
Date: 05.08.03